

Work Order ID 56324

February 17, 2010 2:39:03 PM



Page 1

Item ID: D3953-19

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Bracket

Stop



Start Date: 2/17/10 Start Qty: 4.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

*M*Date: *10-21*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3953

~~CPRELIM~~ *B*

100



Waterjet

FLOW CNC Waterjet

304.125

Memo

1-Cut as per Dwg D3953

Dwg Rev: *005*Prog Rev: *11m*

2-Deburr if necessary

0.00

*B 10-2-22**10*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B 10-2-22

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Sulor/23

0.00

120



QC

Quality Control

Memo

130



Small Fab

Memo

0.00

0.00

Small Fab

1- CHAMFER HOLE AS PER DWG

140



QC

Quality Control

Memo

0.00

0.00

2- DEBURR IF NECESSARY

Sulor/23

(AC)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Identify as per dwg & Stock Location: 119

0.00

-1 'For Basket.

0.00

160



QC

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

10-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 17, 2010 4:08:27 PM

Page 1

Work Order ID: 56324



Parent Item: D3953-19



Parent Item Name: Gas Spring Bracket

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	72.2036	0.0758	3		HR 10-2-22

304/316 0.125 Sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	72.2036	
112663	72.2036	112663

(16)

DART AEROSPACE LTD	Work Order:	56324
Description: GAS SPRING BRACKET	Part Number:	D3953-14
Inspection Dwg: D3953-14 Rev: B		Page 1 of 1

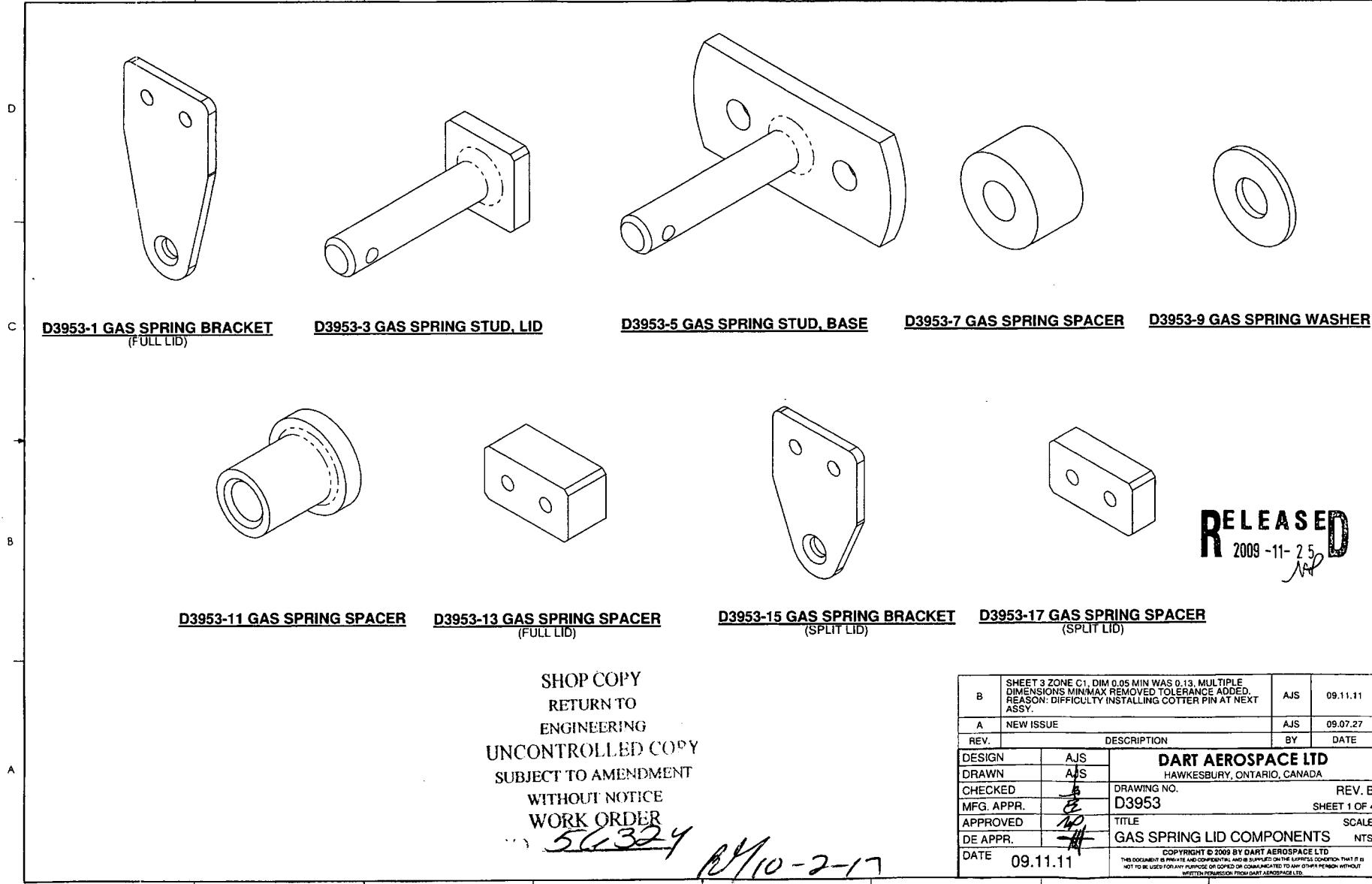
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

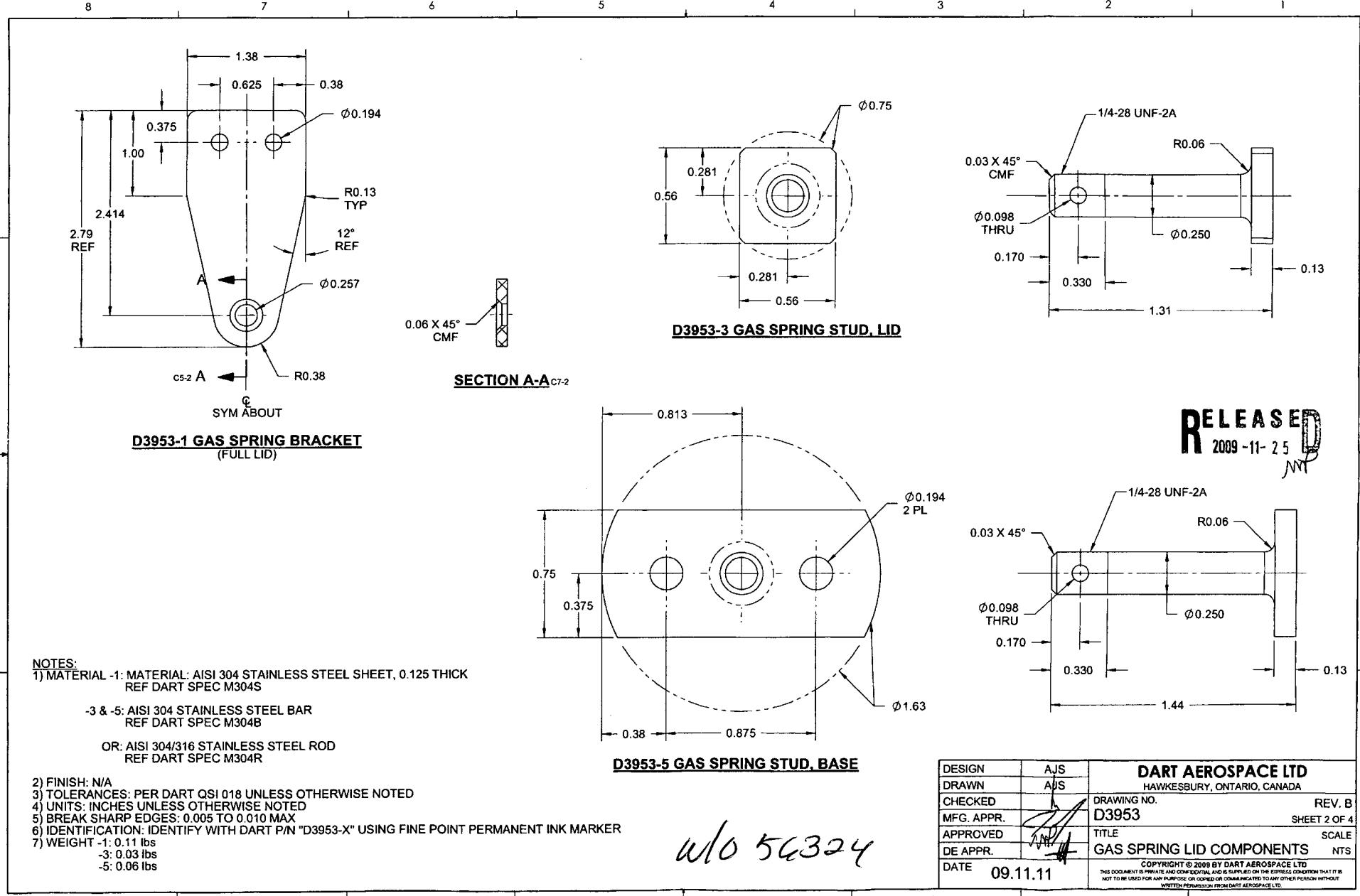
Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	10-2-23	Date:	10/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

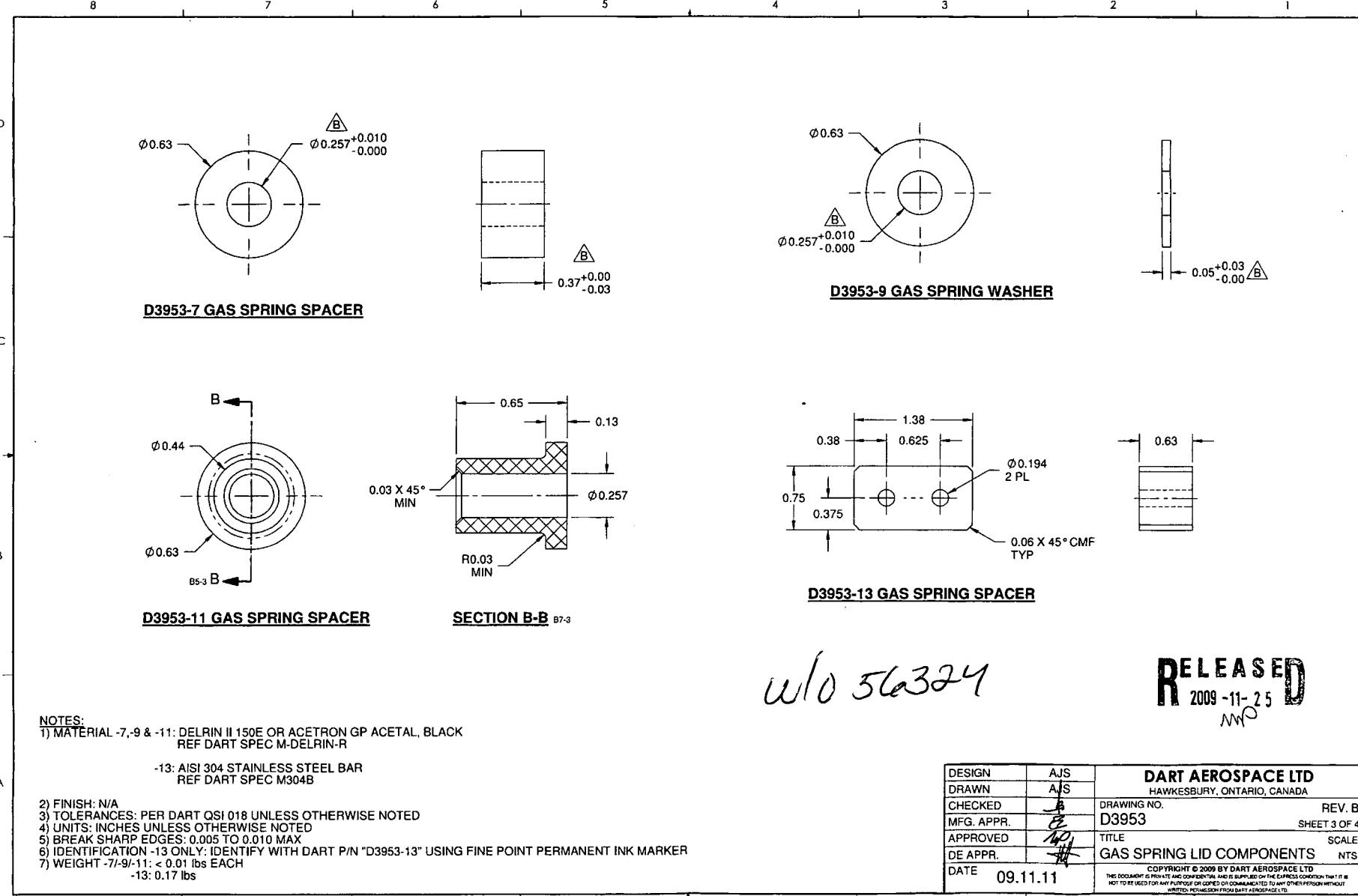
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8 7 6 5 4 3 2 1



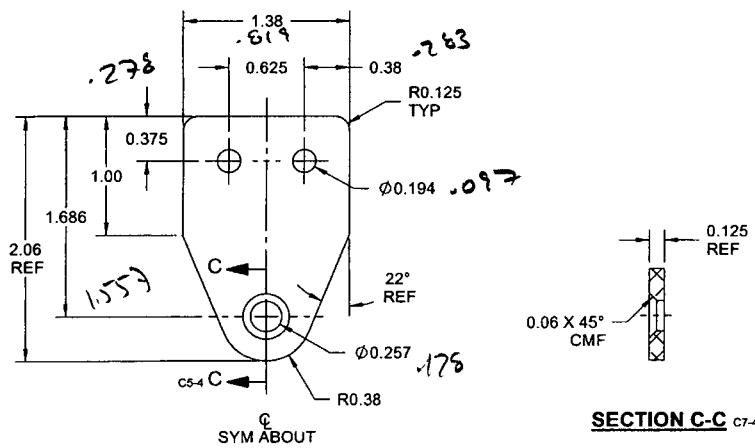
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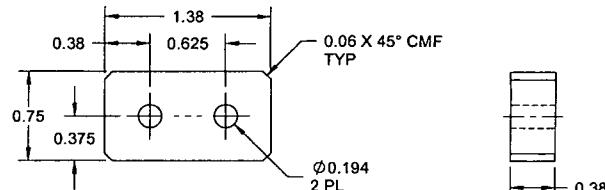
W/0 56324

RELEASED
2009-11-25
MM

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3953
APPROVED	<i>[Signature]</i>	REV. B
DE APPR.	<i>[Signature]</i>	SHEET 3 OF 4
DATE	09.11.11	TITLE
		GAS SPRING LID COMPONENTS NTS
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D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)

W10 56324

RELEASED
2009-11-25
AMC

NOTES:
1) MATERIÁL -15: MATERIAL: AISI 304 STA
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -15: 0.08 lbs
- 17: 0.10 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3953	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING LID COMPONENTS	
DATE	09.11.11	NTS	

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